

BLUE
Work Order ID 62601

October 5, 2010 10:28:31 AM



Page 1

Item ID: D206-667-103BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Fwd, Blue

Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *CS*

Date: *10/10/05* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D206-667-143

C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-103 CHG004

Scrubbing

John BG 10-11-03

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

Packaging

EL 10-10-21

120

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-143 using CNC bender program

EL 10-10-21 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 10/19/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00

5.0/10.25

0.00

(x1)



QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Crosstubes

Crosstubes

Memo

0.00

1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143 Inside of Cuff(Donot engrave on outside of tube)

10-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

SFD
10-70-26

EL 10-70-27.

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

SAD
10-10-22

①

Hand Finishing Crosstubes

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

FS 10/10/28

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S 10/10/28

①

Quality Control

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

Outsource process - NDT per QSI038 4.1

0.00

P/O: 12828

CL 10/10/28

①



Outsource2

Memo

0.00

Outsource process - NDT

CROSSTUBES

190

Packaging

0.00



Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

CL 10/10/28 ①

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

MA 10 10 29 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

0.00



SprayPaint

SprayPaint

Memo

0.00

1-Prime inside and outside crosstube as per QSI 005 4.2

B 115967

2-Paint outside crosstube with ~~White~~ Deflect Blue as per QSI 005 4.2

PRIME:

Start Time: _____

Finish Time: _____

Deflect Blue B 115509

Clear Deflect B 115506

PAINT:

Start Time: _____

Finish Time: _____

Accept Qty: 10 Reject Qty: 11 Reject Number: 01 Insp. Stamp: ①

W
10-10-05

220

0.00



QC14- Inspect Spray Paint

QC

Memo

0.00

Wrap in plastic bag to protect from scratches

Accept Qty: 10 Reject Qty: 11 Reject Number: 02 Insp. Stamp: ①

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00



Crosstubes

Crosstubes

Memo

0.00

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (2) Aft holes should be facing up.
A/R Magnobond 6398 : 115580 exp 07/2011

2-Install supports and clamps as per Dwg D206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

> ml 10-11-03

ml 10 11 02 (1)

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Siolul/03

(76)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/11/35

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 dulos

40

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-103

Location: 179PPP Rev: 10

10/11/35

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 10/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/03
mf
10-11-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

October 5, 2010 10:28:31 AM

Page 1

Work Order ID: 62601

Parent Item: D206-667-103BL

Parent Item Name: Crosstube Fwd, Blue

Start Date: 10/05/10

Required Date: 10/19/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IIP RevA: new issue DD .09.11.23 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-667-103TRN

Manufactured

No

110

Each

2.0000

1

1



Crosstube Turning DetailL

Location

Loc Qty

Loc Code

LG

2

62631

61426

1

61428

1

D2873-043

Manufactured

No

230

Each

16.0000

2

2



Nut Plate Assembly

B# 62380

Location

Loc Qty

Loc Code

ST

16

60981

16

D2873-045

Manufactured

No

230

Each

14.0000

2

2



Nut Plate Assembly

B# 62378

Location

Loc Qty

Loc Code

LG

14

60982

14

D2891-1

Manufactured

No

230

Each

53.0000

2

2



2.25 Support

Blue 1

Location

Loc Qty

Loc Code

LG

53

46159

7

50952

18

53773

20

55786

8

ml 10-11-02

ml 10-11-03

EL 10-10-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D206-667-103BL



Parent Item Name: Crosstube Fwd, Blue

Start Date: 10/05/10

Required Date: 10/19/10

Start Qty: 1.00

Required Qty: 1.00

D3595-063-395

Manufactured No

230

Each

14.0000

4

4



RUBBER CUSHION

B# 63368

Location

Loc Qty

Loc Code

FP

10

44667

10

ST

4

60585

4

cut (4)0.063" X 3.95"

MS20601-AD4W8

Purchased

No

230

Each

174.0000

14

14



RIVET

B# 115855

Location

Loc Qty

Loc Code

ST322

174

108521

70

112203

104

MS21920-20

Purchased

No

230

Each

85.0000

4

4



Clamp (per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG

85

112624

2

114687

1

114779

6

115057

26

115736

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Crosstube Fwd, Blue

Start Date: 10/05/10

Required Date: 10/19/10

Start Qty: 1.00

Required Qty: 1.00

AN5-30A

Purchased

No

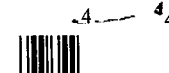
250

Each

78.0000



BOLT



Location

Loc Qty

Loc Code

ST339

78

112933

3

114437

25

114941

50

AN5-32A

Purchased

No

250

Each

300.0000



Bolt



Location

Loc Qty

Loc Code

ST340

300

114056

40

114405

50

115016

50

115108

50

115589

60

115698

50

AN5-7A

Purchased

No

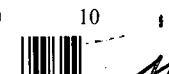
250

Each

139.0000



Bolt



Location

Loc Qty

Loc Code

ST337

139

113149

139

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 10/19/10

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased

No

250

Each

34.0000

18

18



Washer



14114742 10/11/3 SP

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN970-4

Purchased

No

250

Each

86.0000

12

12



Washer



10/11/3 SP

Location

Loc Qty

Loc Code

ST349

86

115531

36

115621

50

MS21042L5

Purchased

No

250

Each

899.0000

4

4



Nut



10/11/3 SP

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

873

115156

373

115594

500

October 5, 2010 10:28:31 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

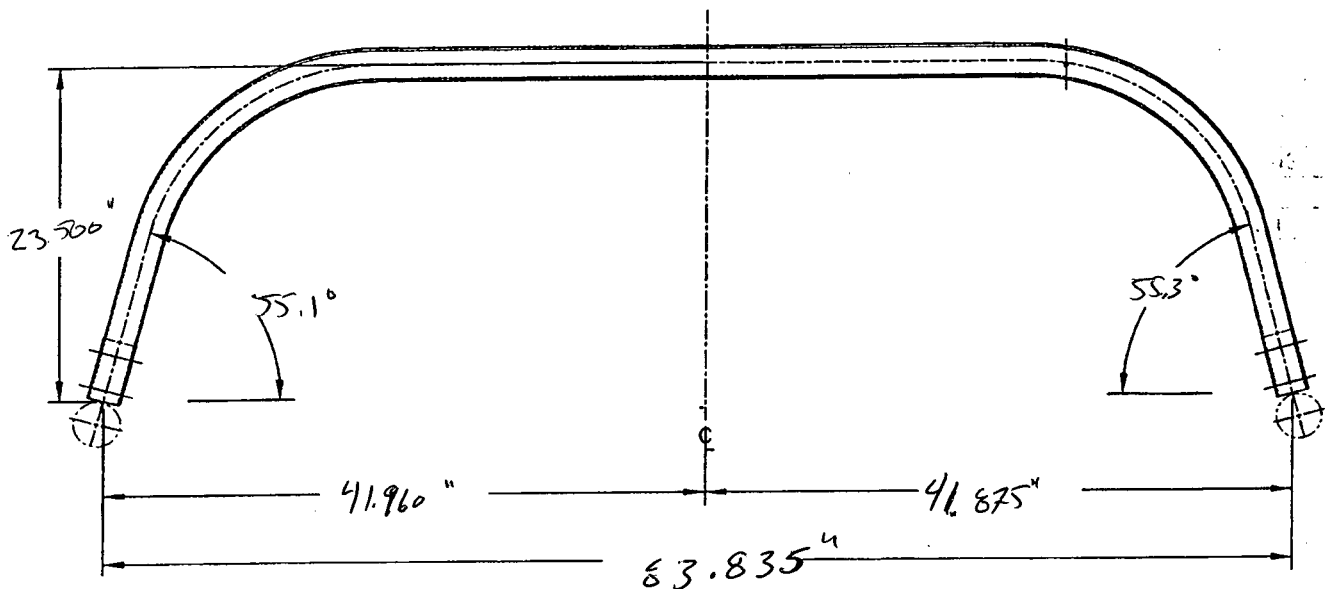
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DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.10



Comments

QC15 Inspection	8
Date	10/10/25

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.06.26	Dimensions updated per Dwg Rev C	KJ	
C	09.10.22	Minimum height dimension revised	KJ	<i>[Signature]</i>

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RB O-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

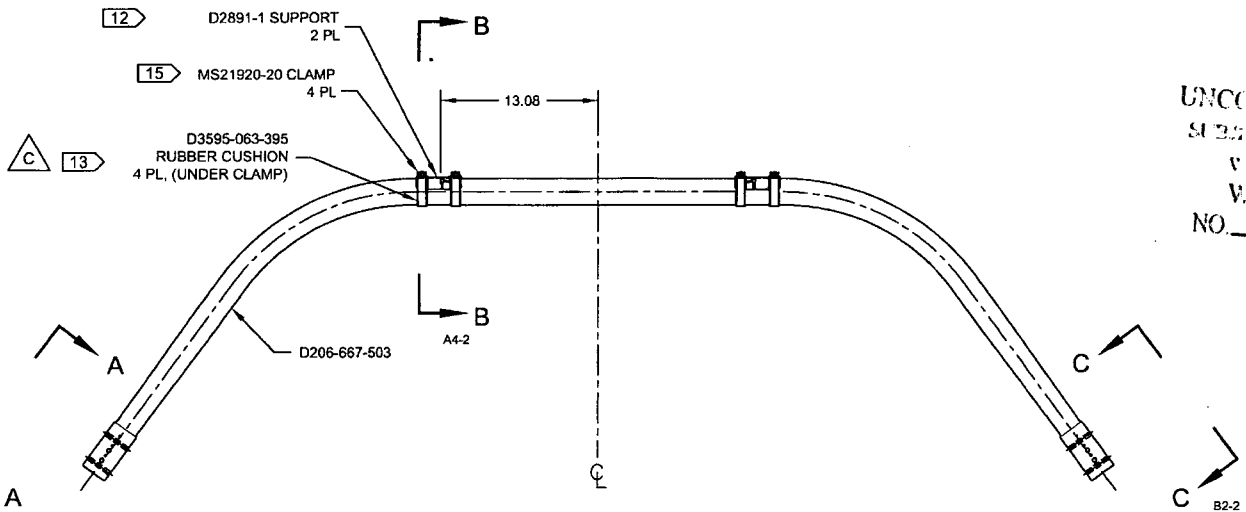
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UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT EFFECT
WORK ORDER
NO. 62601

C&L 10/10/05

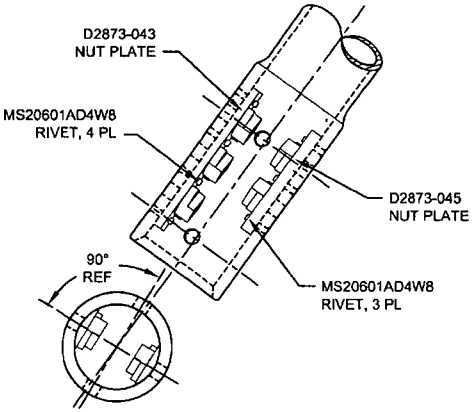
RELEASED
08/11/06

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-143	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

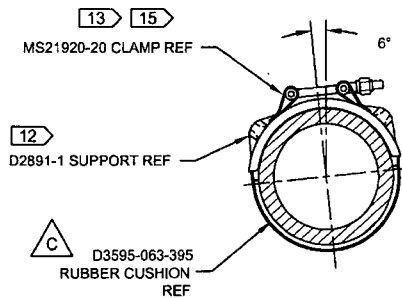
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 NO. 62601



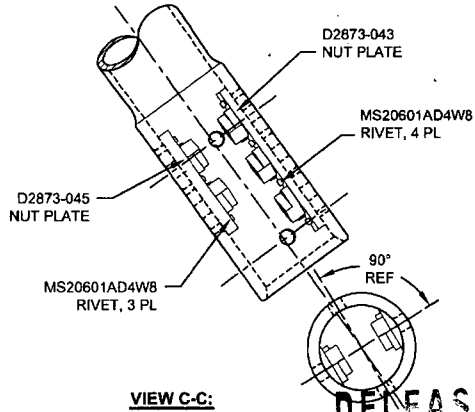
D206-667-143
 ASSEMBLY DETAIL
 (VIEW LOOKING FWD)



VIEW A-A:
 CUFF DETAIL
 SCALE 4X



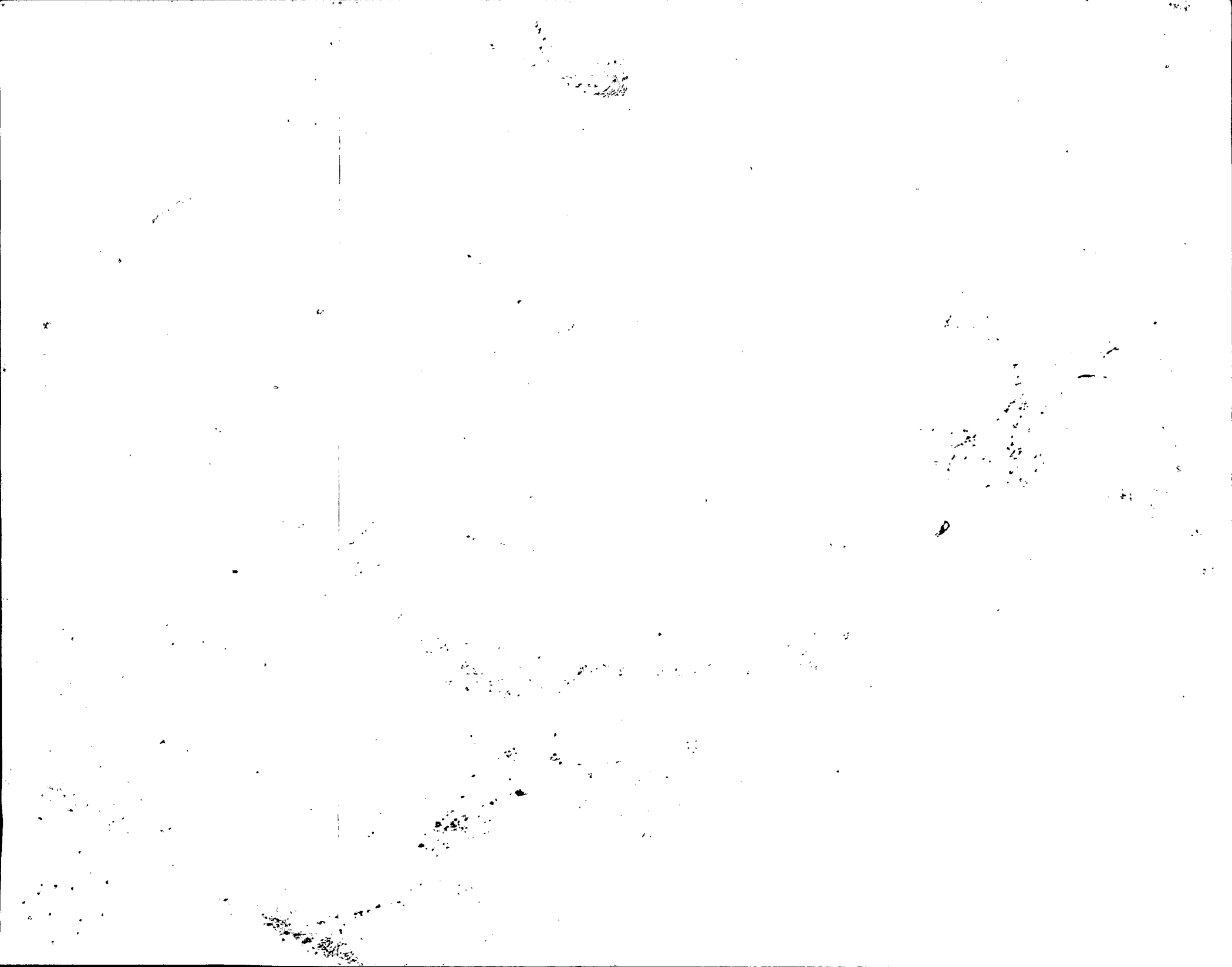
SECTION B-B
 SCALE 5X

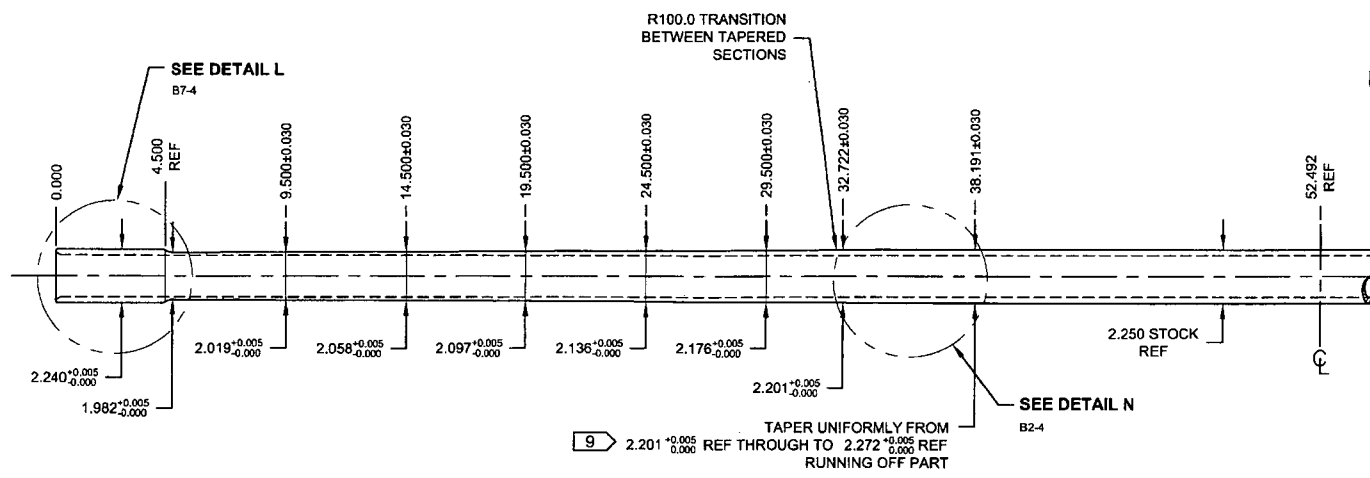


VIEW C-C:
 CUFF DETAIL
 SCALE 4X

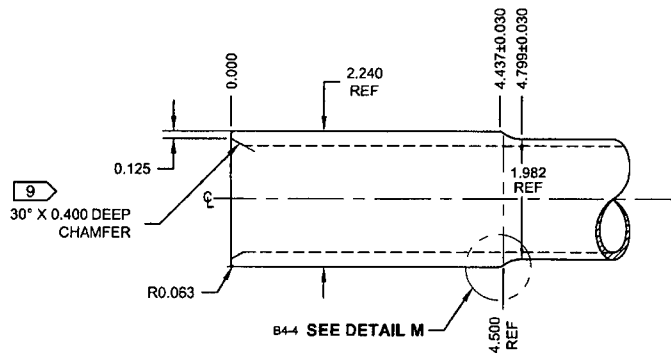
RELEASED
 08/11/12

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	8	DRAWING NO.	REV. C
MFG. APPR.	8	D206-667-143	SHEET 2 OF 4
APPROVED	8	TITLE	SCALE
DE APPR.	8	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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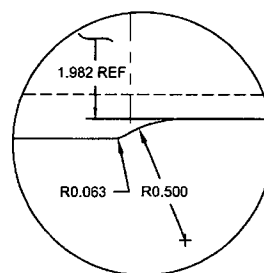




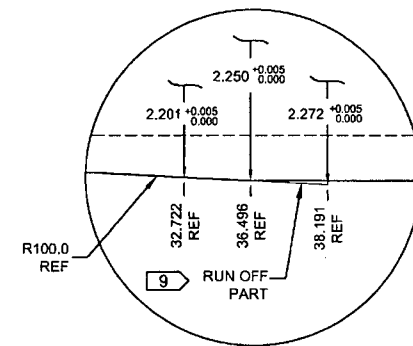
TURNING DETAIL



DETAIL L: CROSSTUBE CUFF
D7-4
NOT TO SCALE



DETAIL M: CUFF TRANSITION
A6-4
NOT TO SCALE



DETAIL N: TAPER RUN-OFF
C4-4
NOT TO SCALE

RELEASED
08/11/06

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D206-667-143	REV. C
MFG. APPR.	JP	SHEET 4 OF 4	
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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REFERENCE ONLY

5.0 PARTS LIST

Item	Qty -011	Qty -013	Qty -015	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X									D206-667-011	SPACER BLOCK KIT
		X								D206-667-013	NUT PLATE KIT (-101/-103/-105/-203/-205)
			X							D206-667-015	NUT PLATE KIT (-201)
				X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
					X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
						X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
							X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
								X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
									X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1				1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2					1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3						1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4							1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5								1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6									1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10				*2	*2	*2		*2		D2891-1	SUPPORT
11							*2			D2892-1	SUPPORT
12									*1	D2894-1	SUPPORT
13				*2	*2	*2		*2		D2856-400-694	ABRASION STRIP
14							*2		*2	D2856-400-773	ABRASION STRIP
15									*1	D2856-600-851	ABRASION STRIP
16				*4	*4	*4		*4		MS21920-20	CLAMP
17							*4		*4	MS21920-22	CLAMP
18									*2	MS21920-24	CLAMP
19				4	4	4		4		AN5-32A	BOLT
20							4		4	AN5-34A	BOLT
21				4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5)
22				8	8	8	8	8	8	AN960JD516	WASHER
23									*2	D3190-1	CHAFING SHIELD
30	8									AN4-6A	BOLT
31	8									AN4-7A	BOLT
32	16									AN960JD416	WASHER
33	2									D3193-041	SPACER BLOCK ASSEMBLY
40		2		*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41		2		*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42			2		2					D2872-043	NUT PLATE
43			2		2					D2872-045	NUT PLATE
44		10		10		10				AN5-7A	BOLT
45		10	10		10		10	10	10	AN5-10A	BOLT
46		4	4	4	10	4		4		AN5-30A	BOLT
47		4					4		4	AN5-32A	BOLT
48		18	18	10	12	10	10	10	10	AN960JD516	WASHER
49		4	4		6					MS21042L5	NUT (OR MS21042-5)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/241/143/243, & D407-667-145/245 ASSEMBLIES ABOVE

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Revision: C

Date: 05.07.26

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2

REF CANADIAN STC: SH01-5
REF FAA STC: SR01304NY
REF EASA STC: EASA.IM.R.S.01179

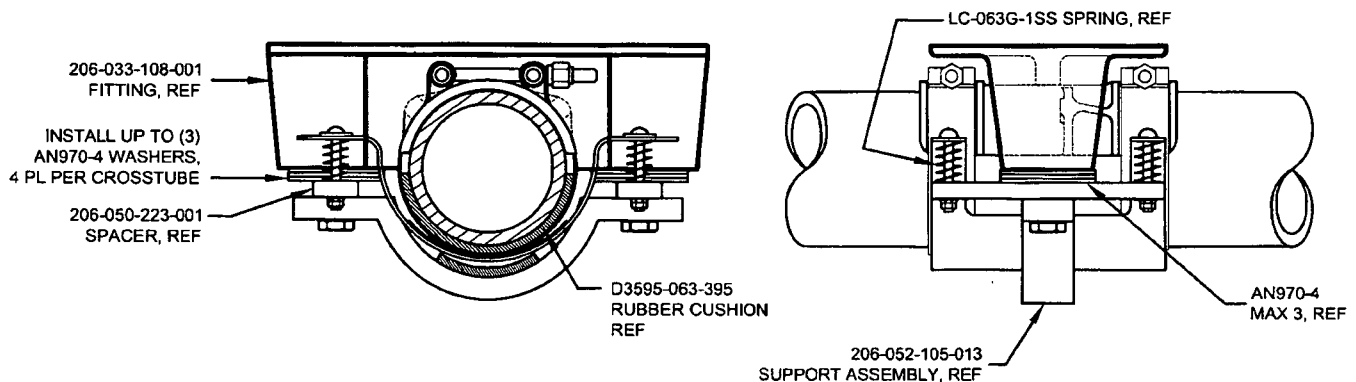
REFERENCE ONLY

PROBLEM:

FOR D206-667-103 CROSSTUBES (206L FWD) AT CHG 003 AND SUBSEQUENT (SEE DSI 9415) PROPER INSTALLATION OF THE OEM SUPPORT ASSEMBLIES MAY BE IMPOSSIBLE DUE TO THE ADDITIONAL THICKNESS OF THE DART D3595-063-395 RUBBER CUSHIONS. THE 206-052-105-013 SUPPORT ASSEMBLY (OR EQUIVALENT) MAY SIT TOO HIGH RELATIVE TO THE 206-033-108-001 FITTING, CAUSING THE LC-063G-1SS SPRING (OR EQUIVALENT) TO BE OVERLY COMPRESSED.

SOLUTION:

IT IS ACCEPTABLE TO LOWER THE SUPPORT ASSEMBLY BY INSTALLING UP TO QTY (3) AN970-4 WASHERS BETWEEN THE 206-033-108-001 FITTING (OR EQUIVALENT) AND THE 206-050-223-001 SPACER (OR EQUIVALENT). SEE FIGURE BELOW FOR REFERENCE.



CROSSTUBE SECTION: SUPPORT DETAIL

PARTS LIST:

THE FOLLOWING PARTS HAVE BEEN INCLUDED WITH D206-667-103 CROSSTUBES AT CHG 004 AND SUBSEQUENT

ITEM	Qty -103	PART NUMBER	DESCRIPTION
60	12	AN970-4	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)
DATE: 08.12.17
CERT. NO.: SH01-5
ISSUE NO.: 3

A	NEW ISSUE	CP	08.12.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>92</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>92</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9439	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206L FWD XTUBE SUPPORT MOD.	NTS
DATE	08.12.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



LIQUID PENETRANT TEST REPORT

P- 15032

PAGE 1 OF 1

CLIENT Dart Aerospace DATE Oct 28 2010 TIME AM ☒ PM ☐
ATTENTION Linda Lacelle ACUREN JOB No. 188-10-0933
ADDRESS 1270 Aberdeen St. POWO No. 117828
Hawkesbury WORK LOCATION Hawkesbury
ACCEPTANCE STD. ASTM 1417/81-038 REV./DATE 2005
PROJECT x-Tubes # D206-667-103 & D206-667-103 BL
ITEM(S) EXAMINED Job #s: 62310, 62743, 62744, 62600, 62601

JOB DESCRIPTION PROCEDURE NO. LT-606Z REV./DATE TECHNIQUE NO. LT-TECH 02 REV./DATE
PART NO. D206-667-103 & D206-667-103 BL MATERIAL ALODINED ALUM THICKNESS N/A
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON
100% EXTERNAL SURFACE OF THE X-TUBES

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND Magnaflux BLACK LIGHT S/N 8178 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT ZL62 MINIMUM DWELL TIME 10-15 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H₂O MINIMUM DRY TIME > 10 MIN. OTHER call oct 15th 2010
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE April 2011
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☒ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

WET FLOURESCENT LIQUID
PENETRANT INSPECTION CARRIED
OUT ON 100% EXTERNAL SURFACE
ON X-TUBES:

Job #s: 62310: Acceptable
62743: Acceptable
62744: Acceptable
62600: Acceptable
62601: Acceptable

10 10 29

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Matt Murdoch DTR # E63201
TECHNICIAN (SIGNATURE): Fredrick Chanson REPORT REVIEWED BY:
NAME (PRINT): FREDRICK CHANSON 1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL # SNT LEVEL # CGSB LEVEL # SNT LEVEL #
CGSB REG. No 12560 CGSB REG. No #